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D5336-043

Job Sheet 196387



Part No: D5336-043

Job Qty: 1 pcs

Part Name: Basket Lid Assembly, LH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/12/19

Job Tracking No:

Due Date: 7/12/19

Created By: Marie Lajeunesse

Type: Stock

Description: SIOP

Note: DWG REV B SHEETS 4,6,7,8 IPP REV:A 15.10.15 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Basket - 1	1 pcs	7/12/19		0.00	6.59	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		DAS
							Large Fab - 6		43
							Large Fab - 7		9-89
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
110	QC 9	1 pcs	7/12/19		0.00	0.00	QC 9 - 10		
							QC 9 - 18	DAS	
							QC 9 - 24	24	
							QC 9 - 43	9-89	
							QC 9 - 50		
							QC 9 - 9		
120	QC 5	1 pcs	7/12/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22	DAS	
							QC 5 - 24	24	
							QC 5 - 3	9-89	
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		

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					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
130 Powdercoat - 4 Black Sand - B4B	1 pcs	7/12/19	0.00	0.13	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	BR 19-9-10
					Powdercoat - 4 - B4B	
140 Handfinish - 3-1- WingWalk- B4B	1 pcs	7/12/19	0.00	0.90	Handfinish - 3 - 1 - B4B	
					Handfinish - 3 - 2 - B4B	BEB 19-09-11
					Handfinish - 3 - 3 - B4B	
					Handfinish - 3 - 4 - B4B	
					Handfinish - 3 - 5 - B4B	
150 QC 3	1 pcs	7/12/19	0.00	0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	W 19-9-11
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
160 Packaging 3-1 - Stock - B4B	1 pcs	7/12/19	0.00	0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	BEB 19-09-11
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	

DAS
15
9-89

				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	DMS
170 QC 21 - SA	1	7/12/19	0.00 0.00	QC 21 - SA - 21	21
	pcs			QC 21 - SA - 70	9-50
				QC 21 - SA - 53	

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Part Op 100 - (Weld per dwg A/R S.S. rod Batch: M13840) 1- Assemble ribs , weld as per dwg D5336 using DT10196 2- Weld Descriptions: hinge (2) and locking brackets as per dwg D5336 ***Inspect before welding mesh*** 3- Cut mesh as per dwg D5334-3 4- Tack weld mesh on basket as per dwg D5336 ***Make sure to place mesh correctly on lid, check with label plate before tacking mesh***

110 - (QC9- Inspect visual per QSI004- Fusion Welds)

120 - (QC5- Inspect part completeness to step on W/O)

130 - (Black Sandtex(Ref:4.3.5.7) per QSI005 4.3) *** Mask holes and sides of hinge prior to powdercoat*** Start Time: 12:00 Oven Temperature: 300° Finish Time: 12:00 M13840.

140 - (Wing Walk as per dwg QSI005 4.4 Batch 5209362) 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg 5209362.

150 - (QC3- Inspect Part Finish)

160 - (Identify as per dwg & Stock Location: _____)

170 - (QC21- Final Inspection - Work Order Release)

#071800

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4016-3	Hinge Half, Lid	2 pcs (2 ea) ✓	100-Large Fab - Basket - 1	5110937
D5332-043 ✓	Rib Assembly	1 pcs (1 ea) ✓	100-Large Fab - Basket - 1	5064682
D5332-11 ✓	Rib	1 pcs (1 ea) ✓	100-Large Fab - Basket - 1	5127454
D5332-15 ✓	Rib	1 pcs (1 ea) ✓	100-Large Fab - Basket - 1	5192525
D5332-17 ✓	Rib	2 pcs (2 ea) ✓	100-Large Fab - Basket - 1	5191776
D5332-7 ✓	Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	5126450
D5332-9 ✓	Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	5126454
D5333-1 ✓	Locking Bracket	1 pcs (1 ea)	100-Large Fab - Basket - 1	5194963
M304EX0.75-16F ✓	Expanded Metal Flat SS	4.8000 sf (4.8 ea)	100-Large Fab - Basket - 1	5188430

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Basket - 1	D4016-3	2	30	0
	D5332-043	1	1	0
	D5332-11	1	2	0
	D5332-15	1	2	0
	D5332-17	2	0	0
	D5332-7	1	2	0
	D5332-9	1	2	0
	D5333-1	1	0	0
	M304EX0.75-16F	5	1,020	0

Part Specifications

Specifications could not be found.

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐		MRB (QS1042)																													
Date : _____		Sequence #: _____		QTY Affected : _____		Disposition																													
Description Work Order Deviation				Completed By																															
				Lead hand / Supervisor																															
				QC / QA Coordinator																															
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY <table border="1"> <tr> <td>Pressure/Forced</td> <td>Contamination</td> <td>Power Loss/Surge</td> <td>Positioned Wrong</td> </tr> <tr> <td>Bending</td> <td>Misaligned/off center</td> <td>Folio/Program</td> <td>Outside Tolerance</td> </tr> <tr> <td>Crushing</td> <td>BOM/Route</td> <td>Grain Direction</td> <td>Drawing</td> </tr> <tr> <td>Cracks</td> <td>Broken/Damage/Defect</td> <td>Weld</td> <td>Finish</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave/Twist</td> <td>Incomplete/Undeclared Instructions</td> <td>Wrong Stock Pulled</td> <td>Part Lost/Missing</td> </tr> <tr> <td>Marks/Chatter</td> <td>Drill Holes</td> <td>Out of Sequence</td> <td>Misread</td> </tr> <tr> <td>Mislabeled</td> <td>Fit/Function</td> <td>Off-set/Set-up</td> <td></td> </tr> </table>						Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong	Bending	Misaligned/off center	Folio/Program	Outside Tolerance	Crushing	BOM/Route	Grain Direction	Drawing	Cracks	Broken/Damage/Defect	Weld	Finish	Crimp/Kink/Ripple/Wave/Twist	Incomplete/Undeclared Instructions	Wrong Stock Pulled	Part Lost/Missing	Marks/Chatter	Drill Holes	Out of Sequence	Misread	Mislabeled	Fit/Function	Off-set/Set-up	
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